

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017720**Date Inspected:** 25-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

NDT

BAY 10

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as OBG Bike path. The weld designations reviewed are as follows.

BK004A4-029-066, 067, BK004A7-029-050, 219, 110  
BK004A4-029-040, 041, BK004A7-029-038, 179, 181, 104,  
BK004A4-029-015, BK004A7-029-032, 166,  
BK004A7-029-224, 231, 225, 232, 198  
BK004A5-029-076, 077, 082, 083, 062, 063, 056, 057, 080, 060  
NDT Notification No-07093

This QA Inspector observed the following work in progress:

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## WELDING INSPECTION REPORT

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BAY 11: SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 041271, 040690 Perform Shielded Metal Arc Welding (SMAW) on Lift 5 Bracket stiffener. Joint identified as ND1-BRSA5-2-6A. ZPMC QC Identified as Zhao Mao Mao. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3212-Tc-U5b.

OBG Bike path plate FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040704, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK4ASD1-024-005, 006. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-B-U2-F. For more information see below attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 053316, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK005A1-003-044. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 040759, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK008A1-002-009. ZPMC QC Identified as Mao Bin Bin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic Particle Testing Inspector, performed MT on OBG Bike path cover plate. Joint identified as BK004A2-021-013, 002, 008, 021. For more information see below attached picture number 2.

BAY 10

OBG Bike path plate Repair welding FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 057180, 500363, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate weld build up 5~6 mm on plate edge. Plate identified as BK004A-29-8A, 8C, 9A, 9C, 10A. ZPMC QC Identified as Lijun with welding repair report WRR-B-WR14881. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-3G (3F) Repair.

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 056200, 052930 Perform Shielded Metal Arc Welding (SMAW) on Tower Façade plate. Joint identified as ND1-SFSA4-630-3, 4, 9, 10. ZPMC QC Identified as Wang Hao. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114.

This QA Inspector observed ZPMC qualified welding personnel identified as 040302, Perform Flux Core Arc Welding (FCAW) on Tower Façade plate. Joint identified as ND1-SFSA4-630-5, 6, 7, 8. ZPMC QC Identified as Wang Hao. The welding parameters as measured using QC's calibrated instrument appeared to be in general

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## WELDING INSPECTION REPORT

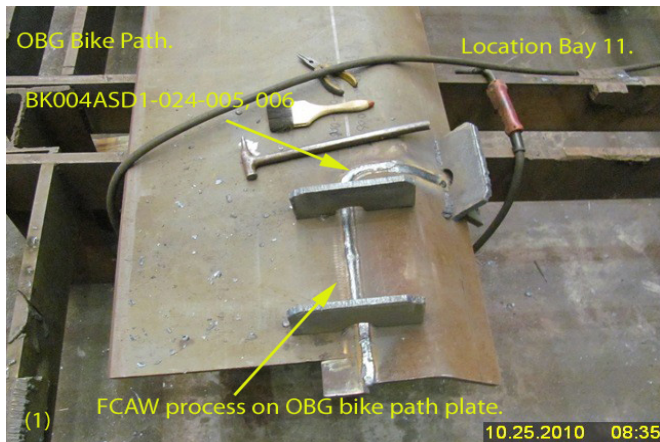
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compliance with WPS-B-P-2132.

This QA Inspector observed ZPMC qualified welding personnel identified as 053869, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A5-026-008. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho phone : 150002048250, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Shailesh

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer

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